

Date: Thursday, 5/11/2006 11:52:10 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE FITTING, FWD (OUTBOARD/INBOARD)
Job Number	: 27057		
Estimate Number	: 10531		
P.O. Number	: N/A	Part Number	: D2572
This Issue	: 5/11/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2572 REV E
First Issue	: N/A	Project Number	: N/A
Previous Run	: 26973	Drawing Revision	: E
	Type	Material	: N/A
		Due Date	: 5/30/2006
Written By	: <u>See Comment Below</u>		Qty: 12 Um: Each
Checked & Approved By	: <u>06.05.11</u>		
Comment	: Est: 1 02:10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101005	7075-T7351 8.25X5.0X2.5
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

7075-T7351 8.25X5.0X2.5

Make from D6101-005 billet for D2572

Ensure that grain is along 5.00" length

Batch No: _____

B24069 x 12 Ep 06/05/15

12

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1Program Batch No. 27057 Double check by: J.G

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets

4-Deburr and remove all machining marks

5-Tumble to remove shap edges.

Ep 06/05/15

J.G

06/05/16

12

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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**Comment:** CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2571 & D2572

Ep 06/05/15

J.G

06/05/16

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/05/25

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 5/11/2006 11:52:11 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 27057

Part Number: D2572

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Enobla 19
5.6

06/05/16

12

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

7m

06/05/23

12

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SAD

06:05:24

12

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m

06/05/24

(12)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

PU

6/5/24

(12)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *51479*

DA

06/05/24

(12)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

PD

06/05/25

(12)

Job Completion



C 206/05/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	27057
Description: Saddle, Fwd Inboard		Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.749	1.748	1.749	1.745		
C	3.495	3.505		3.499	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.748	1.749	1.745		
E	7.990	8.010		8.002	8.004	8.003	8.003		
F	0.490	0.510		0.501	0.502	0.501	0.497		
G	0.257	0.262	DT8683	0.258	0.258	0.258	0.258		
H	0.375	0.380	DT8684	0.376	0.376	0.376	0.376		
I	0.490	0.510		0.502	0.501	0.502	0.496		
J	1.174	1.184		1.180	1.180	1.180	1.178		
K	0.558	0.578		0.569	0.568	0.567	0.566		
L	1.174	1.184		1.180	1.179	1.179	1.178		
M	1.490	1.500		1.494	1.498	1.497	1.495		
N	2.495	2.505		2.499	2.497	2.496	2.499		
O	3.869	3.879		3.872	3.871	3.872	3.871		
P	0.115	0.135		0.121	0.120	0.119	0.121		
Q	0.115	0.135		0.125	0.124	0.125	0.135		
R	0.240	0.260		0.250	0.249	0.248	0.251		
S	0.115	0.135		0.121	0.119	0.119	0.123		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.962	2.961	2.960		
V	0.230	0.250		0.241	0.242	0.241	0.239		
W	0.115	0.135		0.126	0.127	0.126	0.124		
X	0.307	0.312		0.311	0.312	0.311	0.311		
Y	0.760	0.765		0.761	0.761	0.761	0.765		
Z	0.352	0.372		0.364	0.365	0.362	0.362		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.633	0.630	0.629	0.622		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.249	0.247	0.247	0.244		
AE	1.375	1.395		1.387	1.387	1.384	1.385		
AF	0.115	0.135		0.132	0.130	0.130	0.135		
AG	0.240	0.280		0.244	0.247	0.246	0.260		
AH	0.240	0.260		0.251	0.250	0.251	0.245		
AI	2.000	2.020		N/A	N/A	N/A	N/A		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	J.G. / E	Audited by:	J.M.
Date:	06/05/17 / 06/05/18	Date:	06/05/23

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	27057
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.446		
B	1.745	1.755		1.748	1.745	1.748	1.746		
C	3.495	3.505		3.496	3.499	3.496	3.496		
D	1.745	1.755		1.748	1.745	1.748	1.746		
E	7.990	8.010		8.003	8.000	8.002	8.003		
F	0.490	0.510		0.497	0.497	0.498	0.497		
G	0.257	0.262	DT8683	0.258	0.258	0.258	0.258		
H	0.375	0.380	DT8684	0.376	0.376	0.376	0.376		
I	0.490	0.510		0.493	0.494	0.499	0.499		
J	1.174	1.184		1.179	1.175	1.178	1.177		
K	0.558	0.578		0.563	0.562	0.565	0.569		
L	1.174	1.184		1.179	1.175	1.178	1.178		
M	1.490	1.500		1.492	1.494	1.493	1.493		
N	2.495	2.505		2.495	2.497	2.495	2.496		
O	3.869	3.879		3.874	3.874	3.873	3.872		
P	0.115	0.135		0.125	0.124	0.123	0.124		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.250	0.250	0.248	0.250		
S	0.115	0.135		0.125	0.122	0.124	0.124		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.966	2.966	2.960	2.960		
V	0.230	0.250		0.232	0.238	0.233	0.239		
W	0.115	0.135		0.122	0.124	0.118	0.118		
X	0.307	0.312		0.311	0.311	0.311	0.311		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.365	0.368	0.366	0.358		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.623	0.625	0.624	0.624		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.244	0.242	0.240	0.243		
AE	1.375	1.395		1.385	1.385	1.386	1.386		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.242	0.251	0.248	0.248		
AI	2.000	2.020		N/A	N/A	N/A	N/A		
AJ	0.023	0.043		0.033	0.033	0.030	0.030		
Accept/Reject									

Measured by:	3-G/EP
Date:	06/05/17

Audited by:	TR
Date:	06/05/17

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	27056
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443	DT8682	0.441	0.441	0.441	0.441		
B	1.745	1.755		1.745	1.748	1.745	1.745		
C	3.495	3.505		3.498	3.499	3.498	3.499		
D	1.745	1.755		1.745	1.748	1.745	1.745		
E	7.990	8.010		8.000	8.001	8.004	8.002		
F	0.490	0.510		0.497	0.494	0.493	0.494		
G	0.257	0.262	DT8683	0.257	0.257	0.257	0.257		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.495	0.498	0.497	0.496		
J	1.174	1.184		1.175	1.178	1.177	1.176		
K	0.558	0.578		0.566	0.564	0.567	0.566		
L	1.174	1.184		1.175	1.178	1.177	1.176		
M	1.490	1.500		1.497	1.493	1.493	1.494		
N	2.495	2.505		2.497	2.498	2.500	2.495		
O	3.869	3.879		3.873	3.873	3.871	3.872		
P	0.115	0.135		0.126	0.127	0.124	0.124		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.250	0.246	0.249	0.250		
S	0.115	0.135		0.126	0.123	0.123	0.123		
T	0.178	0.198		0.188	0.188	0.189	0.189		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.235	0.239	0.237	0.237		
W	0.115	0.135		0.122	0.122	0.121	0.122		
X	0.307	0.312		0.311	0.310	0.311	0.310		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.370	0.365	0.363	0.366		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.623	0.626	0.625	0.622		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.257	0.246	0.241	0.241		
AE	1.375	1.395		1.388	1.382	1.385	1.385		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.248	0.246	0.246	0.246		
AI	2.000	2.020		N/A	N/A	N/A	N/A		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	ED
Date:	06/05/19

Audited by:	JML
Date:	06/05/23

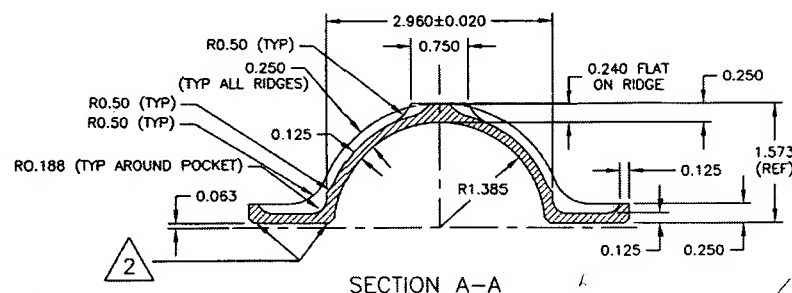
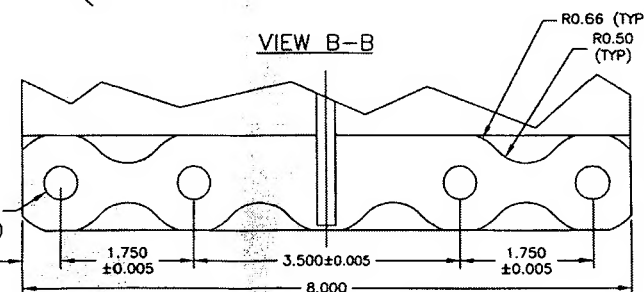
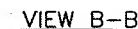
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

05.12.06

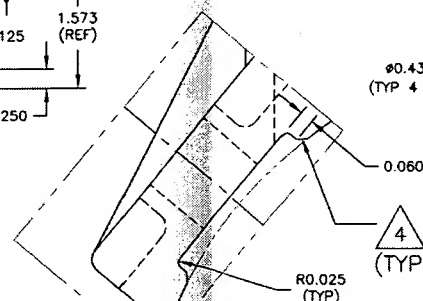


MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-003)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- | | |
|---|--|
| 1 | ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010 |
| 2 | CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES) |
| 3 | CHAMFER 0.063 x 45° ALL AROUND |
| 4 | CHAMFER 0.033 x 45° (SEE DETAIL C) |






SECTION A-A



DETAIL C
SCALE 2:1

E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCRP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

DESIGN	DRAWN BY		DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA
DS	PH		
CHECKED	APPROVED	DRAWING NO.	REV.
		D2572	SHEET 1 OF 2
DATE		TITLE	
05.07.13		INNER FWD SADDLE	

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DESIGN	DS
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DRAWN BY PH

DART

DART AEROSPACE LTD.
HARRISBURG, ONTARIO, CANADA

CHECKED

APPROVED 

DRAWING NO
D2572

REV. E

DATE	
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02572	
TITLE	

SCALE

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